

Date: Friday, 5/25/2007 8:16:31 AM
 User: Kim Johnston

Process Sheet

| | | | | |
|-----------------------|--|--|------------------|-------------|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | WEARSHOE |
| Job Number | 32579 | | Part Number | D265615 |
| Estimate Number | 10613 | | Drawing Number | D2656 REV D |
| P.O. Number | N/A | | Project Number | N/A |
| This Issue | 5/25/2007 S.O. No. N/A | | Drawing Revision | D |
| Prsht Rev. | NC | | Material | N/A |
| First Issue | N/A | | Due Date | 6/10/2007 |
| Previous Run | 31113 | | Qty: | 25 |
| Written By | | | Um: | Each |
| Checked & Approved By | <u>5/07/05-28</u> | | | |
| Comment | Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-09-25 JLM | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--|
| 1.0 | M1010S20GA | 1010/1025/A21/6aA SHEET |
| | | Comment: Qty.: 0.6431 sf(s)/Unit Total : 16.0781 sf(s) 1010/1025/A21/6aA SHEET (.040") (M1010S20GA) Batch: <u>1/104 752</u> SAD 07/06/19 |
| 2.0 | WATER JET | FLOW WATER JET |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> |
| | | 2-Deburr if necessary SAD 07/07/04 26 SAD 07/06/19 26 |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/06/19 26 |
| 4.0 | QC8 | SECOND CHECK |
| | | Comment: SECOND CHECK SAD 07/06/07 26 |
| 5.0 | BRAKE NC | NC BRAKE |
| | | Comment: NC BRAKE 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158 3-Identify as D2656-15 SAD 07/07/16 26 SAD 07/07/18 26 |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DB Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|-------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:16:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32579

Part Number: D265615

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/25/07/13

QC5

7.0 POWDER COATING

POWDER COATING



M104846

QC5

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-J 07/07/20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ML 07/07/21

QC5

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



QC5

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-14

M-J 07/07/23

10.0 QC21

FINAL INSPECTION/W/O RELEASE



QC5

Comment: FINAL INSPECTION/W/O RELEASE

5/25/07/23

Job Completion



ML 07/07/23

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

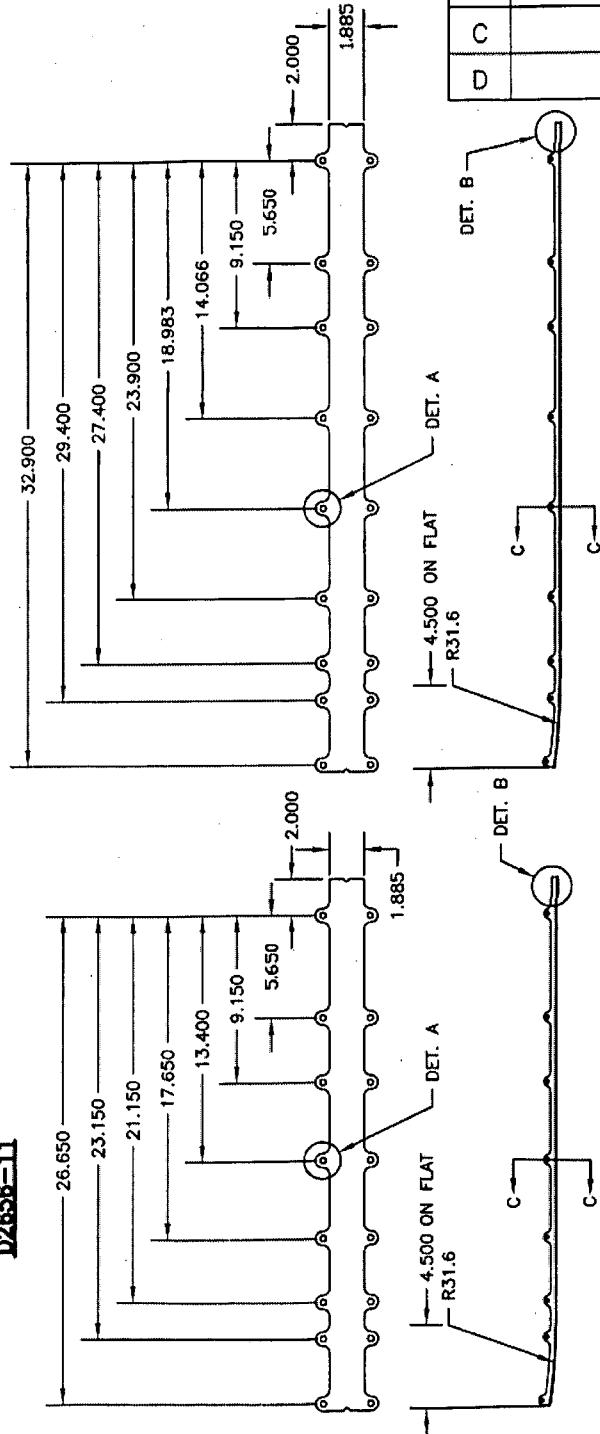
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

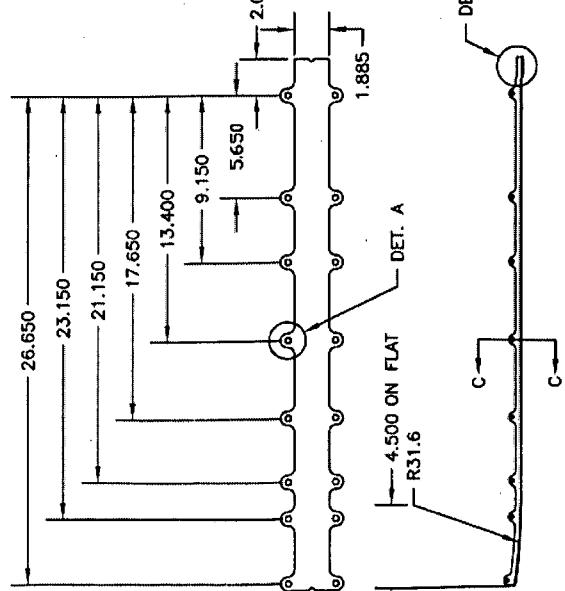
DART

| | | |
|----------|----------|--|
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. D2656 |
| | | REV. D |
| | | SHEET 1 OF 4 |
| DATE | | TITLE |
| 05.08.17 | | WEARSHOE |
| | | SCALE |
| | | 1:10 |
| A | 97:03:25 | NEW ISSUE |
| B | 97:06:02 | CHANGED TABS |
| C | 97:06:26 | R31.6 WAS R19.5 |
| D | 05.08.17 | ENLARGE ALL HOLES TO IMPROVE FIT. |

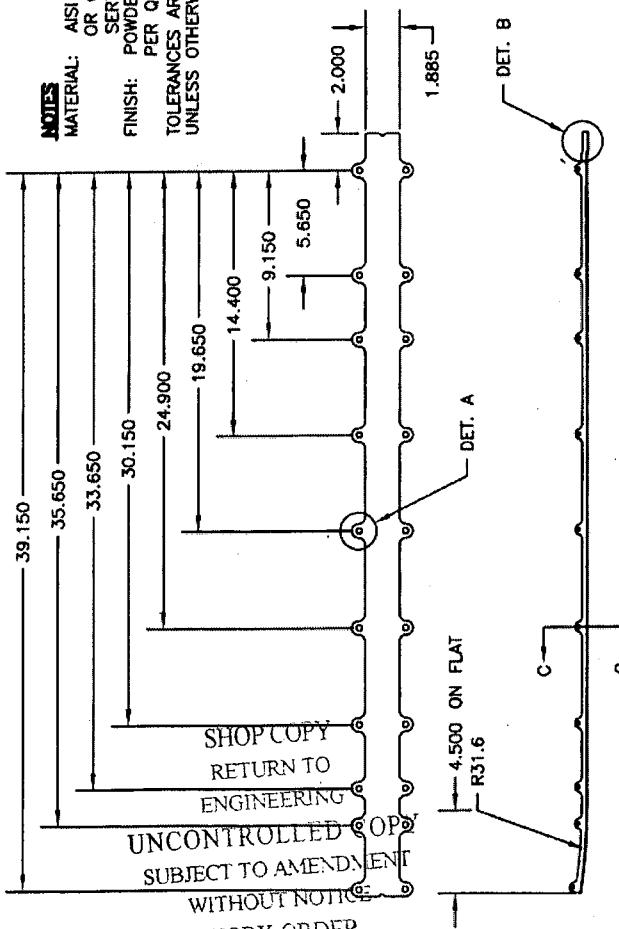
D2656-13



D2656-11



D2656-15



NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A368/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08 *[Signature]*

WORK ORDER
NO 32579

Copyright © 1997 by DART AEROSPACE USA, INC.

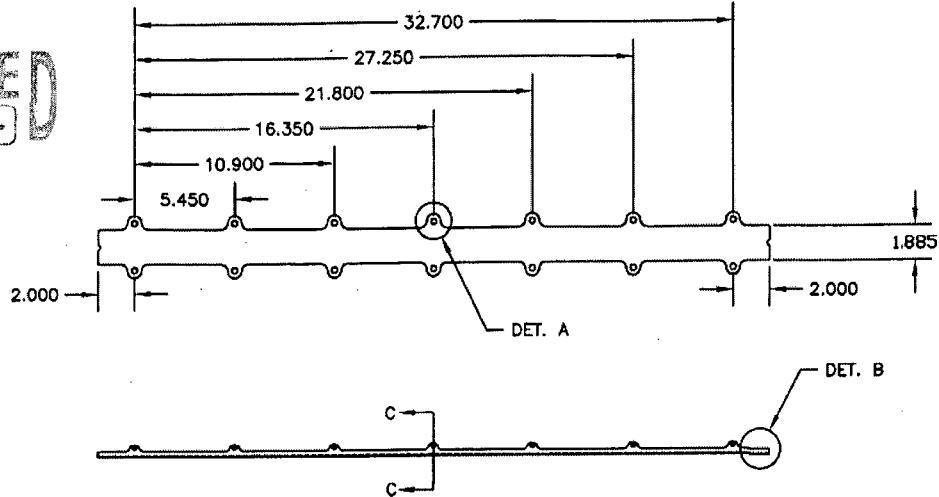
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



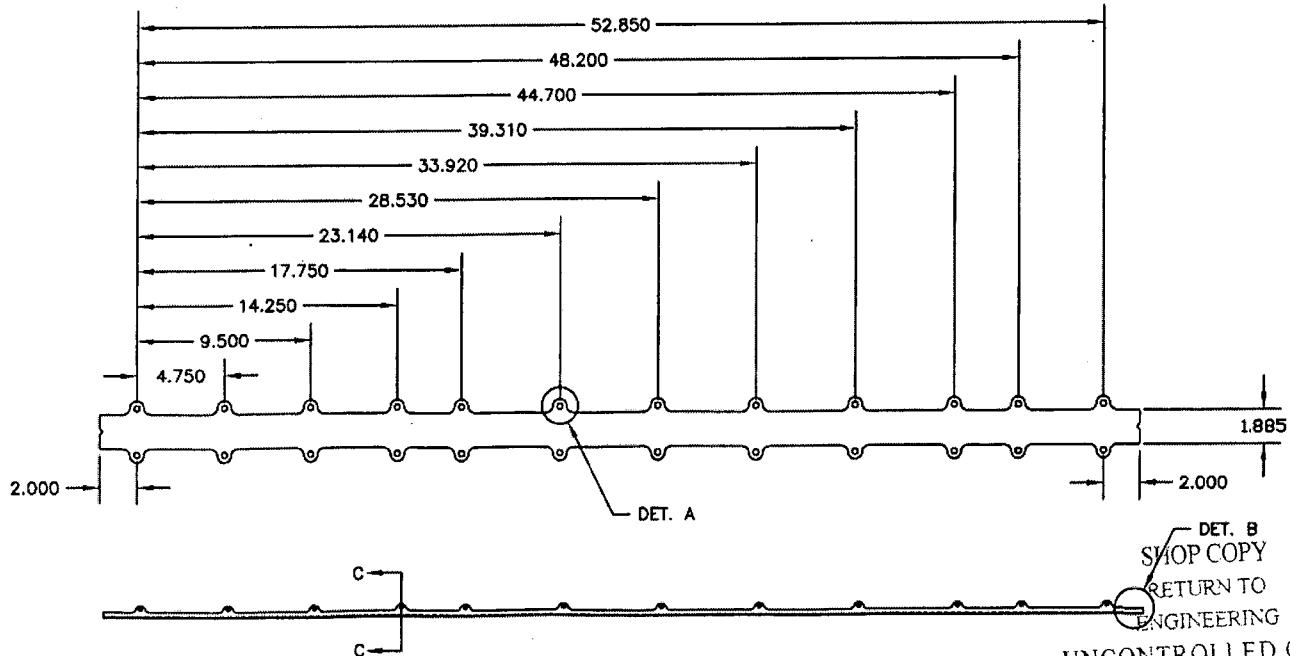
| | | |
|----------|----------|--------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
| DS | CP | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. D2656 |
| | | REV. D SHEET 2 OF 4 |
| DATE | | TITLE |
| 05.08.17 | | WEARSHOE |
| | | SCALE 1:10 |

RELEASED
05.07.06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A365/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

TOLERANCES ARE PER DART QSI 018

UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33579

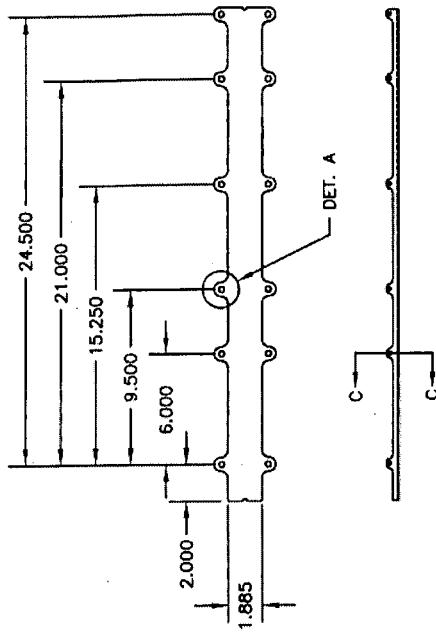
Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

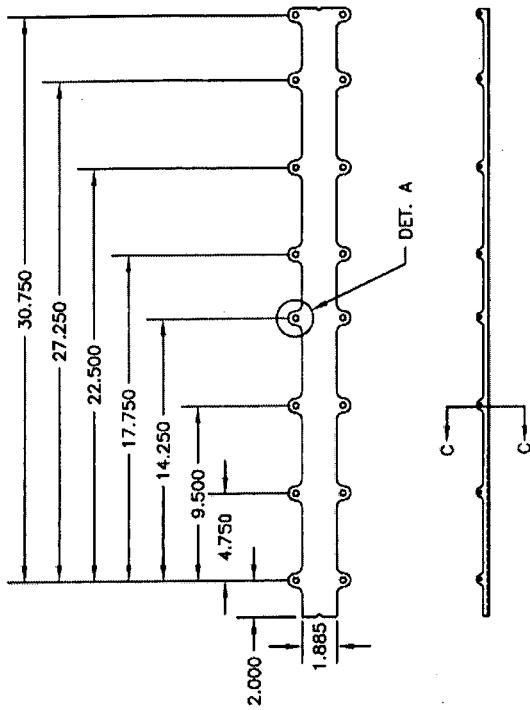


| | | |
|----------|----------|--------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
| DS | CP | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. D2656 |
| | | REV. D |
| DATE | | SHEET 3 OF 4 |
| 05.08.17 | | SCALE |
| | | 1:10 |

D2656-33

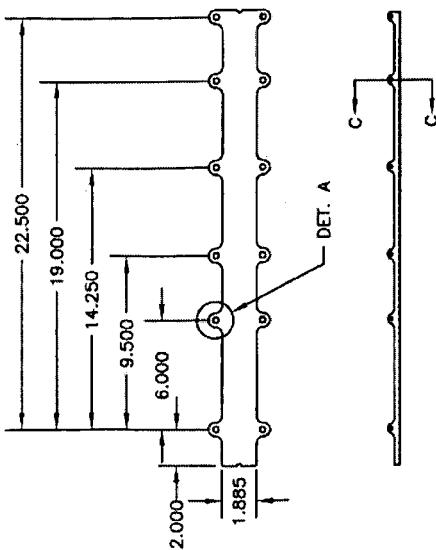


D2656-37

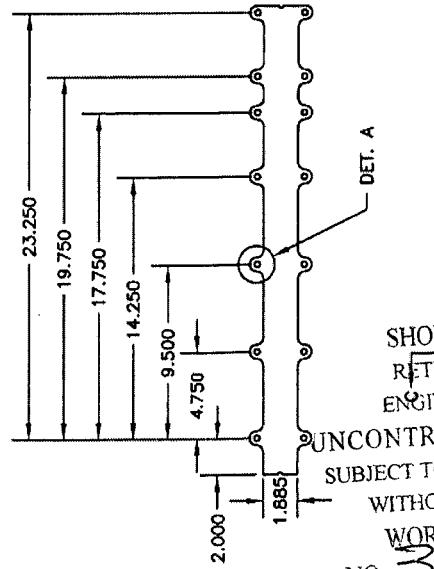


RELEASED
05.09.06

D2656-31



D2656-35



NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32579

Copyright © 1997 by DART AEROSPACE USA, INC.

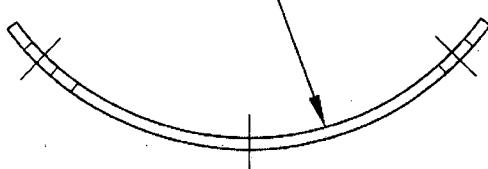
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



| | | | |
|--------------------------------------|--------------------------------------|--|---|
| DESIGN CHECKED DATE | DRAWN BY APPROVED DATE | DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. TITLE | REV. D SHEET 4 OF 4 SCALE 1:10 |
| DS <i>[Signature]</i> 05.08.17 | CP <i>[Signature]</i> 05.08.17 | D2656 WEARSHOE | |

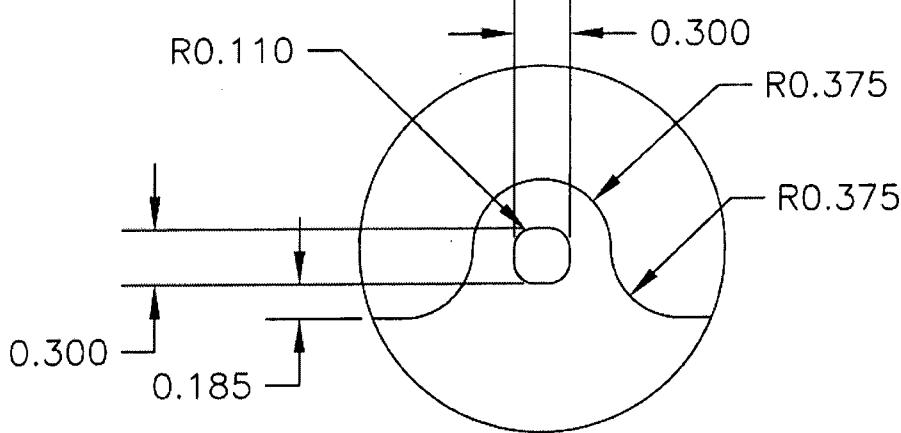
SECTION C-C

R1.62

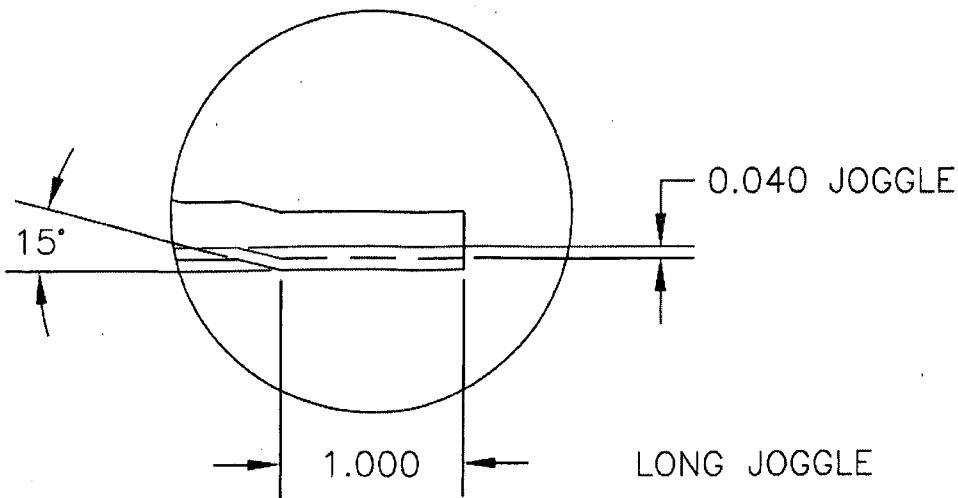


RELEASED
05.09.06

DETAIL A



DETAIL B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32579

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART AEROSPACE LTD

Work Order:

32 579

Description: WEARSHOE

Part Number: D265615

Inspection Dwg: D2656 Rev: D

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------------------|-----------|------------------|--------|--------|----------------------|----------------|
| A 39.150 | +/- 0.010 | 39.150 | ✓ | | M-T | |
| B 35.650 | +/- 0.010 | 35.650 | ✓ | | M-T | |
| C 33.650 | +/- 0.010 | 33.650 | ✓ | | M-T | |
| D 30.150 | +/- 0.010 | 30.150 | ✓ | | M-T | |
| E 24.900 | +/- 0.010 | 24.900 | ✓ | | M-T | |
| F 19.650 | +/- 0.010 | 19.650 | ✓ | | M-T | |
| G 14.400 | +/- 0.010 | 14.400 | ✓ | | M-T | |
| H 9.150 | +/- 0.010 | 9.150 | ✓ | | Vern | |
| I 5.650 | +/- 0.010 | 5.653 | ✓ | | Vern | |
| J 2.000 | +/- 0.010 | 2.000 | ✓ | | Vern | |
| K 1.885 | +/- 0.010 | 1.892 | ✓ | | Vern | |
| L 0.040 | +/- 0.010 | 0.035 | ✓ | | Vern | MFT. Thickness |
| M 0.300 | +/- 0.010 | 0.298 | ✓ | | Vern | |
| N 0.300 | +/- 0.010 | 0.299 | ✓ | | Vern | |
| O | | | | | | |
| P | | | | | | |
| Q | | | | | | |
| R | | | | | | |
| S | | | | | | |
| T | | | | | | |
| U | | | | | | |
| V | | | | | | |
| W | | | | | | |
| X | | | | | | |
| Y | | | | | | |

| | |
|--------------|----------|
| Measured by: | SAW |
| Date: | 07/06/19 |

| | |
|-------------|----------|
| Audited by: | Sp |
| Date: | 07/06/19 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | KJ/RF | |

